Work Order ID 116513

April-17-14 7:45:17 AM

116513

Item ID: D4806-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Clevis **Stop** *NS2*

Start Date: 4/16/14 **Start Qty:** 2.00 *2*

Required Date: 5/01/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-04-17 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4806	**Revision Nbr** Rev. B per ECN 14-573 ~~Rev A~~								
100		0.00							
100									
Outsource1	**Memo**	0.00				CL 14/04/17 2			
Outsource process - Heat Treat	Issue P/o: 23860 Possible supplier: ATG C OF IS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				2			
110									
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				2			
120									
QC	**Memo**	0.00							
Quality Control									

Date of AFG 4/6/17 DAS 27 9-89

14/6/17 DAS 27 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4806-1
Revision ID:
Item Name: Clevis

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 4/16/14 **Start Qty:** 2.00 *2*
Required Date: 5/01/14 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 **Memo** ISSUE P/O : C OF C IS REQUIRED	0.00 0.00				CL 14/06/27			
140 *140* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs **Memo**	0.00 0.00				2X SP 14-6-27			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							

done@ ATC
N/A.

DAS 16 9-89 14.6.27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4806-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Clevis

Start Date: 4/16/14 **Start Qty:** 2.00 *2*
Required Date: 5/01/14 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST 22	0.00							
160						2x	14-7-1		DAS 26 9-89
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170						MJ	14-07-03		
QC	**Memo**	0.00							
Quality Control									

MF

14-7-01

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Centre Not Concentric
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☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
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☐ Cut Too Short
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☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-17-14 7:45:21 AM

Work Order ID: 116513

116513

Parent Item: D4806-1

D4806-1

Parent Item Name: Clevis

Start Date: 4/16/14 **Required Date:** 5/01/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4806-1P		Purchased	No				Each	0.0000	**	2			
D4806-1P Clevis										2x SP 14-6-27			
M174PH-H900R1.000		Purchased	No				f	145.0000	**	1			
M174PH-H900R1.000 17-4SS H900 ROUND BAR 1.00										CR 14/04/17			

Location	Loc Qty	Loc Code
MAT031	145	
m126952	37	
m127334	60	
m128314	48	

1

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23860

Purchase Order Date 4/17/2014
PO Print Date 4/22/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED 04/24/14

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	613-446-4544	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Nbr	Reference / Vendor Part Number / Line Comments / Delivery Comments	Description/ Mfg ID	Req Date/ Taxable / Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	D4806-1P	Clevis	5/19/2014 Yes 5/19/2014	FN	2.00 Each	$235.00	$470.
	MACHINE AS PER DWG D4806 REV. A B116513 MATERIAL: 174PH-H900R1.000 M126952						
						Line Total:	$470.
2	D4808-1P	Rod End	5/19/2014 Yes 5/19/2014	FN	8.00 Each	$71.75	$574.
	MACHINE AS PER DWG D4808 REV. A B116516 MATERIAL: 174PH-H900R1.000 M126952						
						Line Total:	$574

SP14-6-27

Note:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 908161 Date: 24-Jun-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description			
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.			
2 ea	Part: D4806-1P CLEVIS Job: 16212	PO: PO23860	Rev: A Line: 1	SP14-6-27
4 ea	Part: D4920-1P END FITTING Job: 16221	PO: PO23860	Rev: A Line: 10	
4 ea	Part: D4920-3P END FITTING Job: 16222	PO: PO23860	Rev: A Line: 11	
4 ea	Part: D4884-3P END FITTING, EYE Job: 16225	PO: PO23860	Rev: A Line: 15	

DATE : 24 June 2014

CERTIFIED SIGNATURE: JAyotte

RECEIVER SIGNATURE : _____

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

I.S.O. 9001 : 2008 REGISTERED / MADE IN CANADA

First Article Inspection Repo

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	June 23rd, 2014	498
Part Number:	D4806-1P	Revision:	A	
PO Number:	PO23860	Qty:	2	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	R1.00	✓	
2	1.38	1.379	
3	.015 x 45º Chamfer	.015 x 75º	
4	1.08	1.08	
5	R.13	.125	
6	R.44	R.437	
7	.250	.249	
8	Ø.374/.375 thru	.3745	
9	Ø.043	.045	
10	Ø.55	.550	
11	.750	.750	
12	2.30	2.302	
13	2.70	2.701	
14	Ø.84	.836	
15	.313	.312	
16	.625	.624	
17	.59	.293	
18	Ø.348	Ø.347	
19	.375-24 UNF-3B x .700 DP	3/8-24 x.725	
20	2.00	1.985	
21	Material:	17-4SS H900 1.00" RD BAR	Supplied by Customer
22	Treatment:	Liquid Penetrant	PO#: 20140237

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21262	**Customer:** ATG Industries Inc	**Dept:** NDT YUL	**Reference:** 20100237
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 2 CLEVIS P/N : D4806-1P , 9 END FITTINGS P/N : D4920-1P AND 4 END FITTINGS P/N : D4920-3P

Action Taken:	Date:	Initial/Stamp:
LPI C/O AS PER E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	JUN 2 0 2014	MB DOT - APP 15 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		**ACA/SCA Stamp**	Date:
Name:	M. BEAUCHAMP	DOT - APP 15 53-89	JUN 2 0 2014

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21262	**Customer:** ATG Industries Inc	**Dept:** NDT YUL	**Reference:** 20100237
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 2 CLEVIS P/N : D4806-1P , 9 END FITTINGS P/N : D4920-1P AND 4 END FITTINGS P/N : D4920-3P

Action Taken:	Date:	Initial/Stamp:
LPI C/O AS PER E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	JUN 20 2014	MB DOT-APP 15 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		**ACA/SCA Stamp** DOT-APP 15 53-89	Date: JUN 20 2014
Name:	M. BEAUCHAMP		

COPY